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(12) **United States Patent**  
**Jarvis et al.**(10) **Patent No.:** **US 9,102,772 B2**(45) **Date of Patent:** **\*Aug. 11, 2015**(54) **THICKENING VINYL COPOLYMERS**USPC ..... 526/318.2, 318.43; 525/301  
See application file for complete search history.(71) Applicant: **Conopco, Inc.**, Englewood Cliffs, NJ  
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(US)

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patent is extended or adjusted under 35  
U.S.C. 154(b) by 0 days.This patent is subject to a terminal dis-  
claimer.

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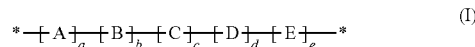
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C08F 222/06

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*Primary Examiner* — Michael M Bernshteyn(74) *Attorney, Agent, or Firm* — Ronald A. Koatz(57) **ABSTRACT**

A rheology modifier copolymer of formula (I) wherein A is a polyacidic vinyl monomer selected from maleic, fumaric, itaconic, citraconic and acid combinations thereof and anhydrides and salts thereof, B is an acrylic or methacrylic acid or salt thereof; C is a C<sub>1</sub>-C<sub>8</sub> ester of (meth)acrylic acid; D is an associative monomer; and optionally E is a crosslinking monomer.

**7 Claims, No Drawings**

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## THICKENING VINYL COPOLYMERS

## BACKGROUND OF THE INVENTION

## 1. Field of the Invention

The invention relates to thickening vinyl copolymers, particularly hydrophobically modified alkali-swellable or alkali-soluble emulsion polymers.

## 2. The Related Art

Rheology modifiers are used as thickeners and structurants in a variety of consumer and industrial products. They affect product performance, aesthetics, application and suspension, and delivery of active chemical agents. Rheology modifiers are generally classed in several categories dependent on the mechanism by which they thicken.

Hydrodynamic thickeners work by utilizing acid groups in their structure that when neutralized form anionic charges. These repel each other causing the polymer chains to expand and entangle. Thickening and suspending effects of the neutralized polymers are due to increased physical packing of the molecules. These materials are also known as "space filling" or "volume exclusion". Both viscosity and yield point increase with concentration. The alkali swellable emulsions (ASE) and carbomers fall within this category.

Associative thickeners operate by a twin mechanism. They utilize the aforementioned hydrodynamic thickening method. Secondly, they utilize the association of hydrophobic groups on the polymer backbone with other hydrophobic species. The latter can be other hydrophobic polymer groups, oils, particles and the like. Association creates hydrophobic regions distributed throughout the polymer chain network. This also renders the polymers as effective solubilizing agents. The hydrophobically modified alkali swellable emulsions (HASE) fall into this category.

HASE/ASE polymers are produced by oil-in-water emulsion polymerization. Most consist of a lightly crosslinked backbone of ethyl acrylate and methacrylic acid.

U.S. Pat. No. 4,529,773 (Witiak et al.) reports alkali-soluble emulsion polymers activated by neutralization to a pH above 6.5, and subsequently acidified in the presence of a surfactant. These are described as useful thickeners in acidified containing compositions. The polymers are best formed from a 3-component monomer system of methacrylic or acrylic acid, methacrylic or acrylic acid ester of a C<sub>8</sub>-C<sub>30</sub> alkyl or hydrocarbyl monoether of polyethylene glycol, and a C<sub>1</sub>-C<sub>4</sub> alkyl acrylate or methacrylate.

U.S. Pat. Nos. 7,649,047 B2 and 7,288,616, both to Tamareselvy et al., disclose multi-purpose alkali-swellable and alkali-soluble associative polymers. They are formed from polymerizing a monomer mixture of at least one acidic vinyl monomer, at least one nonionic vinyl monomer, a first associative monomer having a first hydrophobic end group, a second associative monomer having a second hydrophobic end group, and a crosslinking or chain transfer agent. These patents describe the HASE type chemistry. A commercial product based on this chemistry is the Lubrizol Corp. supplied Aqua SF-1®.

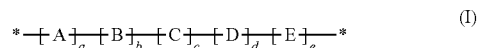
WO 2010/026097 A1 (Graham et al.) describes rheology modifiers for use in home and personal care compositions. These modifiers are formed from four monomers. They include an amino-substituted vinyl monomer, a hydrophobic nonionic vinyl monomer (such as a C<sub>1</sub>-C<sub>30</sub> alkyl ester of acrylic or methacrylic acid), an associative-like monomer (with a polyoxyalkylene unit end-capped with a hydrophobic group), and a further associative-like vinyl monomer.

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Although the aforementioned disclosures and their commercial embodiments provide rheology modifying solutions, there still is a need for improvements in thickening profile and suspension clarity.

## SUMMARY OF THE INVENTION

A rheology modifier is provided which is a copolymer of formula (I)

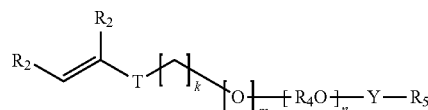


wherein a, b, c, d and e represent the percentage by weight that each repeating unit monomer is contained within the copolymer;

A is a polyacidic vinyl monomer selected from the group consisting of maleic, fumaric, itaconic, citraconic and acid combinations thereof and anhydrides and salts thereof; and B is acrylic or methacrylic acid or a salt thereof;

C is a C<sub>1</sub>-C<sub>8</sub> ester of acrylic acid or methacrylic acid;

D is an associative monomer of formula (II)



wherein each R<sub>2</sub> is independently H, methyl, —C(=O)OH, or —C(=O)OR<sub>3</sub>;

R<sub>3</sub> is a C<sub>1</sub>-C<sub>30</sub> alkyl;

T is —CH<sub>2</sub>C(=O)O—, —C(=O)O—, —O—, —CH<sub>2</sub>O—, —NHC(=O)NH—, —C(=O)NH—, —Ar—(CE<sub>2</sub>)<sub>z</sub>—NHC(=O)O—, —Ar—(CE<sub>2</sub>)<sub>z</sub>—NHC(=O)NH—, or —CH<sub>2</sub>CH<sub>2</sub>NHC(=O)—;

Ar is divalent aryl;

E is H or methyl;

z is 0 or 1;

k is an integer in the range of 0 to 30; and m is 0 or 1;

with the proviso that when k is 0, m is 0, and when k is in the range of 1 to 30; m is 1;

(R<sub>4</sub>)<sub>n</sub> is polyoxyalkylene, which is a homopolymer, a random copolymer, or a block copolymer of C<sub>2</sub>-C<sub>4</sub>-oxyalkylene units, wherein R<sub>4</sub> is C<sub>2</sub>H<sub>4</sub>, C<sub>3</sub>H<sub>6</sub>, C<sub>4</sub>H<sub>8</sub>, or a mixture thereof, and n is an integer in the range of 5 to 250;

Y is —R<sub>4</sub>O—, —R<sub>4</sub>H—, —C(=O)—, —C(=O)NH—, —R<sub>4</sub>NHC(=O)NH—, or —C(=O)NHC(=O)—; and

R<sub>5</sub> is substituted or unsubstituted alkyl selected from the group consisting of C<sub>8</sub>-C<sub>40</sub> linear alkyl, C<sub>8</sub>-C<sub>40</sub> branched alkyl, C<sub>8</sub>-C<sub>40</sub> carbocyclic alkyl, C<sub>2</sub>-C<sub>40</sub> alkyl-substituted, phenyl, aryl-substituted C<sub>2</sub>-C<sub>40</sub> alkyl, and C<sub>8</sub>-C<sub>80</sub> complex ester; wherein the R<sub>5</sub> alkyl group optionally comprises one or more substituents selected from the group consisting of hydroxy, alkoxy, and halogen; and

E when present is a cross linking monomer for introducing branching and controlling molecular weight, the cross linking monomer comprising polyfunctional units carrying multiple reactive functionalization groups selected from the group consisting of vinyl, allylic and functional mixtures thereof, the groups A, B, C, D and E being covalently bonded one to another in a manner selected from a random, a block or a cross-linked copolymer format.

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Amounts of "a" may range from about 0.1 to about 10% by weight; amounts of "b" may range from about 10 to about 80% by weight; amounts of "c" may range from about 30 to about 85% by weight; amounts of "d" may range from about 1 to about 25% by weight; and amounts of "e" may range from 0 to about 5% by weight of the total copolymer.

#### DETAILED DESCRIPTION OF THE INVENTION

Now we have found a copolymer system that thickens well and provides good clarity to relatively high salt content aqueous systems of low pH. The copolymers are based on a combination of monomers that include a polyacidic vinyl monomer such as a maleic derivative, a monoacid vinyl monomer such as an acrylic or methacrylic acid, an acrylate ester monomer, an associative monomer, and optionally a cross linking

##### Monomer A

The copolymer will include a polyacidic vinyl monomer A which may be a di-, tri- or higher acid functionalized ethylenically unsaturated monomer unit. Normally the acid group will be a dicarboxylic acid or salt thereof. Illustrative acids are maleic, fumaric, itaconic and citraconic acids and salts thereof as well as combinations of these. Most preferred are maleic derivatives. Accordingly, the most preferred species are maleic acid, maleic anhydride or a salt thereof. Salts include the mono- and the di-salt of maleic. In one embodiment maleic acid can be generated from maleic anhydride as starting material and hydrolyzing this to the di acid in the emulsion polymerization.

Monomer A may range from about 0.1 to about 10%, preferably from about 0.3 to about 5%, and more preferably from 0.4 to 1%, and optimally from 0.4 to 0.6% by weight of the total copolymer.

##### Monomer B

Acidic vinyl monomers B suitable for use are acrylic acid, methacrylic acid, salts of the aforementioned acids and combinations thereof.

In certain embodiments, the acid groups may already be neutralized forming salts. Typical salt counterions to the acid groups are sodium, potassium, ammonium and triethanolammonium cations.

Amounts of the monoacidic vinyl monomer in the copolymers may range from about 10 to about 80%, preferably from about 25 to about 70%, more preferably from about 40 to about 50% by weight of the total copolymer.

##### Monomer C

The copolymer may include monomers C formed from one or more  $C_1$ - $C_8$  esters of acrylic or methacrylic acid. Illustrative ester monomers are ethylacrylate, methylacrylate, ethyl methacrylate, methylmethacrylate, butylacrylate, butylmethacrylate and mixtures thereof.

When present, the amount of acrylate ester monomers in the copolymer may range from about 30 to about 85%, preferably from about 45 to 75%, and more preferably from about 50 to about 70% by weight of the total copolymer.

##### Monomer D

Associative vinyl monomers D suitable for use in the production of the copolymers are compounds preferably having an ethylenically unsaturated end group portion (i) for addition polymerization with the other monomers of the system; a polyoxyalkylene midsection portion (ii) for imparting selective hydrophilic properties to the product polymer; and a hydrophobic end group portion (iii) for providing selective hydrophobic properties to the polymer.

The portion (i) supplying the ethylenically unsaturated end group preferably is derived from an alpha, beta-ethylenically

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unsaturated mono or dicarboxylic acid or the anhydride thereof, more preferably  $C_3$ - $C_4$  mono- or dicarboxylic acid or the anhydride thereof. Alternatively, portion (i) of the associative monomer can be derived from an allyl ether or vinyl ether; a nonionic vinyl-substituted urethane monomer, such as disclosed in U.S. Reissue Pat. 33,156 or U.S. Pat. No. 5,294,692; or a vinyl-substituted urea reaction product, such as disclosed in U.S. Pat. No. 5,011,978.

The midsection portion (ii) is preferably a polyoxyalkylene segment of about 5 to about 250, more preferably about 10 to about 120, and most preferably about 15 to about 60 repeating  $C_2$ - $C_7$  alkylene oxide units. Preferred midsection portions (ii) include polyoxyethylene, polyoxypropylene, and polyoxybutylene segments comprising about 5 to about 150, more preferably about 10 to about 100, and most preferably about 15 to about 60 ethylene, propylene or butylene oxide units, and random or non-random sequences of ethylene oxide, propylene oxide and or butylene oxide units.

The hydrophobic end group portion (iii) of the associative monomers is preferably a hydrocarbon moiety belonging to one of the following hydrocarbon classes:  $C_8$ - $C_{40}$  linear alkyl, aryl-substituted  $C_2$ - $C_{40}$  alkyl,  $C_2$ - $C_{40}$  alkyl-substituted phenyl,  $C_8$ - $C_{40}$  branched alkyl,  $C_8$ - $C_{40}$  carbocyclic alkyl; and  $C_8$ - $C_{80}$  complex ester.

Examples of suitable hydrophobic end group portions (iii) of the associative monomers are linear or branched  $C_8$ - $C_{40}$  alkyl groups such as capryl, isooctyl, decyl, lauryl, myristyl, cetyl, cetearyl, stearyl, isostearyl, arachidyl, behenyl and mixtures thereof.

Examples of suitable  $C_8$ - $C_{80}$  complex esters include hydrogenated castor oil (predominately the glyceride of 12-hydroxystearic acid); 1,2-diacyl glycerols such as 1,2-distearyl glycerol, 1,2-dipalmityl glycerol, 1,2-dimyristyl glycerol, and the like; di-, tri-, or polymers of sugars such as 3,4,6-tristearyl glucose, 2,3-dilauryl fructose, and the like; and sorbitan esters such as those disclosed in U.S. Pat. No. 4,600,761.

U.S. Pat. No. 4,074,411 describes several processes for preparing associative monomers. These associative monomers are sometimes referred to as "vinyl surfactant esters" or "surfmers". These associative monomers may typically be prepared by the acid catalyzed condensation of commercially available nonionic polyoxyalkylene surfactant alcohols with acrylic, methacrylic, crotonic, maleic, fumaric, itaconic or acetic acid.

Particularly preferred associative vinyl monomers include cetyl polyethoxylated methacrylate, cetearyl polyethoxylated methacrylate, stearyl polyethoxylated (meth)acrylate, arachidyl polyethoxylated (meth)acrylate, behenyl polyethoxylated methacrylate, lauryl polyethoxylated methacrylate, hydrogenated castor oil polyethoxylated methacrylate, and canola polyethoxylated (meth)acrylate, wherein the polyethoxylated portion of the monomer comprises about 5 to about 100, preferably about 10 to about 80, and more preferably about 15 to about 60 ethylene oxide repeating units.

Amounts of the associative vinyl monomer may range from about 1 to about 25%, preferably from about 3 to about 20%, and more preferably from about 8 to about 15% by weight of the total copolymer.

##### Monomer E

One or more cross linking monomers E may be present in the copolymer for purposes of introducing branching and controlling molecular weight. These monomers will be polyunsaturated. Illustrative but not limiting examples are divinyl benzene, divinyl naphthalene, trivinyl benzene, triallyl pentaerythritol, diallyl pentaerythritol, diallyl sucrose, octaallyl sucrose, trimethylol propane diallyl ether, 1,6-hexanediol

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di(meth)acrylate, tetramethylene tri(meth)acrylate, trimethylol propane tri(meth)acrylate, polyethoxylated glycol di(meth)acrylate, alkylene bisacrylamides, bisphenol A polyethoxylated dimethacrylate, trimethylolpropane polyethoxylated trimethacrylate and similar materials. Preferred for the present invention is bisphenol A polyethoxylated glycol diacrylate, diallyl pentaerythritol and trimethylolpropane triacrylate.

Amounts of the cross linking monomer may range from 0 to about 5%, preferably from about 0.05 to about 3%, more preferably from about 1 to about 2%, optimally from about 0.2 to about 1% by weight of the total copolymer.

#### Formulations with Rheology Modifiers

Rheology modifying copolymers of this invention can be used in a broad range of industrial and consumer products. These may be found in industries such as adhesives, lubricants (machine and motor vehicle), oil drilling fluids, pharmaceuticals, paints, inks and personal care formulations. Most advantageously, the copolymers are suitable for personal care compositions such as body wash, shampoos, creams and lotions, hair colorants, toothpastes, lipsticks and other color cosmetics.

Common to many of the personal care compositions besides the rheological modifier is one or more surfactants. The surfactants may be anionic, nonionic, cationic, zwitterionic and amphoteric and mixtures thereof. Amounts of the surfactants may range from 0.1 to 30%, and preferably from 5 to 20% by weight of the compositions.

Preferred nonionic surfactants are those with a  $C_{10}$ - $C_{20}$  fatty alcohol or acid hydrophobe condensed with from 2 to 100 moles of ethylene oxide or propylene oxide per mole of hydrophobe;  $C_2$ - $C_{10}$  alkyl phenols condensed with from 2 to 20 moles of alkylene oxide; mono- and di-fatty acid esters of ethylene glycol; fatty acid monoglyceride; sorbitan, mono- and di- $C_8$ - $C_{20}$  fatty acids; and polyoxyethylene sorbitan as well as combinations thereof. Alkyl polyglycosides and saccharide fatty amides (e.g. methyl gluconamides) and trialkylamine oxides are also suitable nonionic surfactants.

Preferred anionic surfactants include soap ( $C_8$ - $C_{22}$  fatty acid salts); alkyl ether sulfates and sulfonates, alkyl sulfates and sulfonates, alkylbenzene sulfonates, alkyl and dialkyl sulfosuccinates, acyl isethionates, alkyl ether phosphates, sarcosinates, acyl lactylates, sulfoacetates and combinations thereof. The term "alkyl" or "acyl" encompasses from 7 to 24 carbon atoms. Normally the aforementioned anionic surfactants are salts featuring sodium, potassium or ammonium counterions.

Useful amphoteric surfactants include ccoamidopropyl betaine,  $C_{12}$ - $C_{20}$  trialkyl betaines, sodium lauroamphoacetate, and sodium laurodiamphoacetate. Cationic surfactants are represented by  $C_8$ - $C_{22}$  alkyl trimethylammonium salts such as cetyltrimethylammonium chloride.

Formulation compositions containing the copolymers of this invention may also include a carrier. Amounts of the carrier may range from 1 to 95%, preferably from 50 to 90%, optimally from 65 to 85% by weight of the composition. Among the useful carriers are water, esters, hydrocarbons, fatty acids, fatty alcohols, thickeners and combinations thereof. The carrier may be aqueous, anhydrous or an emulsion. Preferably the compositions are aqueous, especially water and oil emulsions of the W/O or O/W or triplex W/O/W variety.

All documents referred to herein, including all patents, patent applications, and printed publications, are hereby incorporated by reference in their entirety in this disclosure.

The term "comprising" is meant not to be limiting to any subsequently stated elements but rather to encompass non-

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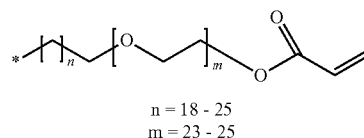
specified elements of major or minor functional importance. In other words the listed steps, elements or options need not be exhaustive. Whenever the words "including" or "having" are used, these terms are meant to be equivalent to "comprising" as defined above.

Except in the operating and comparative examples, or where otherwise explicitly indicated, all numbers in this description indicating amounts of material ought to be understood as modified by the word "about".

It should be noted that in specifying any range of concentration or amount, any particular upper concentration can be associated with any particular lower concentration or amount.

#### EXAMPLE 1

##### Associative Monomer Synthesis



Brij® 35 (75 g) was dissolved in 400 ml anhydrous dichloromethane under a nitrogen atmosphere and cooled in an ice bath to 5° C. Triethylamine (10.45 g) was added via syringe. Acryloyl chloride was dispersed in 20 ml anhydrous dichloromethane and added dropwise over a 30 minute period. After complete addition the solution was allowed to warm to room temperature and the reaction stirred over night. The solution was filtered to remove precipitate and washed twice with saturated sodium hydrogen carbonate solution (2×200 ml) and once with saturated brine (200 ml). The product was dried with anhydrous sodium sulphate, filtered and further dried in vacuo. In subsequent examples the product is referred to as Brij®35 surfmer.

##### Typical HASE Polymer Synthesis

A round bottom flask was charged with ethyl acrylate (25.8 g), methacrylic acid (17.6 g), maleic anhydride (1.7 g), Brij® 35 surfmer (4.28 g), trimethylolpropane triacrylate (0.14 g) and 30% sodium dodecyl sulfonate (SDS) solution (1.57 g). The mixture was sealed and purged with nitrogen for 30 minutes before adding deoxygenated water (12.2 g) and stirring into a pre-emulsion. A multineck round bottom flask was fitted with a nitrogen sparge and overhead stirrer. Deoxygenated water (85.5 g) and 30% SDS solution (0.48 g) were added, stirred at 250 rpm and heated to 85° C. Ammonium persulfate (0.034 g) in water (1 ml) was added via syringe. The pre-emulsion was fed into the surfactant solution via peristaltic pump over 60 minutes. After complete addition the temperature was increased to 95° C. and ammonium persulfate (0.015 g) in water (1 ml) was added and the reaction stirred for a further 90 minutes.

#### EXAMPLE 2

Several copolymers were prepared for comparative performance purposes using the typical HASE polymer synthesis outlined at the end of the preceding Example. Table I details the monomer components of the synthesized polymers and their respective viscosities. The Table lists the actives in grams based on 100 grams of emulsion for the HASE synthesis. Not listed is the surfactant SDS (sodium dodecyl sulfonate) emulsifier and ammonium persulfate.

## Preparation of Formulations

Sodium Lauryl Ether Sulfate (160.71 g) was dissolved in water (1106.25 g) aided by mixing with an overhead stirrer. To the solution was added the polymer solution (60 ml), Kathon CG/ICP II (1.5 ml) and finally Tegobetaine® CK KB 5 (125.00 g). The solution was split into 145 ml aliquots from which base formulations I, II, III and IV were made up as follows:

Formulation I (pH 5.9, 0.68% NaCl): An overhead stirrer was used to mix an aliquot (145 g) of the base solution. The pH was adjusted to pH 5.90 using sodium hydroxide (0.1 M). Sodium chloride (1.125 g) was slowly added and topped with further water (3.875 g).

Formulation II (pH 5.9, 1.58% NaCl): An overhead stirrer was used to mix an aliquot (145 g) of the base solution. The pH was adjusted to pH 6.75 using sodium hydroxide (0.1 M). Sodium chloride (2.25 g) was slowly added and topped with further water (2.75 g).

Formulation III (pH 6.75, 0.68% NaCl): An overhead stirrer was used to mix an aliquot (145 g) of the base solution. The pH was adjusted to pH 6.75 using sodium hydroxide (0.1 M). Sodium chloride (1.125 g) was slowly added and topped with further water (3.875 g).

Formulation IV (pH 6.75, 1.58% NaCl): An overhead stirrer was used to stir an aliquot (145 g) of the solution base. The pH was adjusted to pH 6.75 using sodium hydroxide (0.1 M). Sodium chloride (2.25 g) was slowly added and finally water (2.75 g).

## Clarity Measurements

Clarity was measured using a SpectraMax Microplate Spectrophotometer for UV/VIS absorbance measurements at 420 nm. Nunc Nuclon D microtitre plates with well capacity of 200 microlitres were used for the measurements. Each well was loaded with 150 microlitres of sample and four wells were used for each sample with an average value being taken. The value for demineralized water was then deducted from the value.

Clear (transparent) is defined as 0-0.2 absorbance.

Haze (translucency) is defined as 0.21-0.9 absorbance.

Opaque defined is as at least 0.91 absorbance.

## Viscosity Measurements

An Anton Paar ASC32 Rheometer was used to measure viscosity. Viscosities are reported as Pa·s taken at 23° C. with shear rate of 0.1 s<sup>-1</sup>

Viscosity and clarity performance results of the copolymer Samples in surfactant formulations I, II, III and IV are presented in the lower half of Table I.

TABLE I

Component	Sample (Weight Grams)			
	A	B	C	D
Ethyl Acrylate	22.81	21.96	23.80	22.81
Methacrylic Acid	13.91	14.94	13.10	14.1
Maleic Acid	0.19	—	—	—
Brij® Surfmier (Active basis)	3.69	3.69	3.69	3.69
Trimethylolpropane Triacrylate	0.203	0.203	0.203	0.203
Water	balance	balance	balance	balance
Viscosity (Pa · s) at pH 5.9 and NaCl (%)				
0.68%	70.37 (c)	19.9 (h)	25.7 (h)	42.3 (c)
1.58%	270.9 (c)	40.5 (h)	53.8 (c)	83.3. (c)
Viscosity (Pa · s)				

TABLE I-continued

Component	Sample (Weight Grams)			
	A	B	C	D
at pH 6.75 and NaCl (%)				
0.68%	75.3 (c)	25.1 (h)	10.0 (o)	28.0 (o)
1.58%	322 (c)	84.2 (c)	31.5 (h)	64.1 (h)

<sup>1</sup>Polyethylhexylmethacrylate (1500 mw)  
<sup>2</sup>Polybutylmethacrylate (950 mw)  
(c) Clear formulation  
(h) Hazy formulation  
(o) Opaque formulation

Sample A is a copolymer illustrative of the present invention. Samples B, C and D were prepared and evaluated for comparative purposes. Viscosities at pH 5.9 and pH 6.75 were much thicker for Sample A than those under the same conditions for the comparative Samples B, C and D. In most instances, the inventive Sample A exhibited a viscosity more than 2 to 9 times that of the comparatives. The clarity of Sample A copolymer was clear under all conditions. By contrast, Samples B, C and D experienced conditions where the copolymer turned the formulation hazy or even opaque.

## EXAMPLE 3

A series of copolymers according to the present invention are detailed in Table II according to their monomer content. Ordinarily the resultant copolymer is suspended through emulsification in an aqueous system.

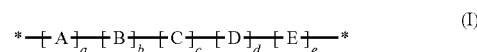
TABLE II

Monomer	Copolymer (Weight Percent)					
	1	2	3	4	5	6
Ethyl Acrylate	65.0	71.0	69.4	57.3	—	—
Methyl Acrylate	—	—	—	—	42.7	53.3
Methacrylic Acid	23.5	11.9	17.6	30.2	41.0	35.7
Maleic Acid	3.0	9.1	5.0	4.5	8.0	7.6
Brij® Surfmier (Active Basis)	8.0	7.7	7.7	7.7	8.0	2.9
Trimethylolpropane Triacrylate	0.5	0.3	0.3	0.3	0.3	0.5

In summary, the present invention is described above in terms of a preferred and other embodiments. The invention is not limited, however, to the described and depicted embodiments. Rather, the invention is only limited by the claims appended hereto.

The invention claimed is:

1. A rheology modifier a copolymer of formula (I)



wherein a, b, c, d and e represent the percentage by weight that each repeating unit monomer is contained within the copolymer, and being:

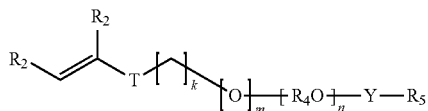
a ranges from about 0.1 to about 10% by weight of the copolymer;

b ranges from about 10 to about 80% by weight of the copolymer;

c ranges from about 30 to about 85% by weight of the copolymer;

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d ranges from about 1 to about 25% by weight of the copolymer; and  
 e ranges from 0 to about 5% by weight of the copolymer;  
 A is a polyacidic vinyl monomer selected from the group consisting of maleic, fumaric, itaconic, citraconic and acid combinations thereof and anhydrides and salts thereof; and  
 B is acrylic or methacrylic acid or a salt thereof;  
 C is a C<sub>1</sub>-C<sub>8</sub> ester of acrylic acid or methacrylic acid;  
 D is an associative monomer of formula (II)



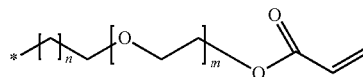
wherein each R<sub>2</sub> is independently H, methyl, —C(=O)OH, or —C(=O)OR<sub>3</sub>;  
 R<sub>3</sub> is a C<sub>1</sub>-C<sub>30</sub> alkyl;  
 T is —CH<sub>2</sub>C(=O)O—, —C(=O)O—, —O—, —CH<sub>2</sub>O—, —NHC(=O)NH—, —C(=O)NH—, —Ar—(CE<sub>2</sub>)<sub>z</sub>—NHC(=O)O—, —Ar—(CE<sub>2</sub>)<sub>z</sub>—NHC(=O)NH—, or —CH<sub>2</sub>CH<sub>2</sub>NHC(=O)—;  
 Ar is divalent aryl;  
 E is H or methyl;  
 z is 0 or 1;  
 k is an integer in the range of 0 to 30; and m is 0 or 1;  
 with the proviso that when k is 0, m is 0, and when k is in the range of 1 to 30; m is 1;  
 (R<sub>4</sub>O)<sub>n</sub> is polyoxyalkylene, which is a homopolymer, a random copolymer, or a block copolymer of C<sub>2</sub>-C<sub>4</sub>-oxyalkylene units, wherein R<sub>4</sub> is C<sub>2</sub>H<sub>4</sub>, C<sub>3</sub>H<sub>6</sub>, C<sub>4</sub>H<sub>8</sub>, or a mixture thereof, and n is an integer in the range of 5 to 250;  
 Y is —R<sub>4</sub>O—, —R<sub>4</sub>H—, —C(=O)—, —C(=O)NH—, —R<sub>4</sub>NHC(=O)NH—, or —C(=O)NHC(=O)—; and  
 R<sub>5</sub> is substituted or unsubstituted alkyl selected from the group consisting of C<sub>8</sub>-C<sub>40</sub> linear alkyl, C<sub>8</sub>-C<sub>40</sub> branched alkyl, C<sub>8</sub>-C<sub>40</sub> carbocyclic alkyl, C<sub>2</sub>-C<sub>40</sub> alkyl-substituted, phenyl, aryl-substituted C<sub>2</sub>-C<sub>40</sub> alkyl, and C<sub>8</sub>-C<sub>80</sub> complex ester; wherein the R<sub>5</sub> alkyl group optionally comprises one or more substituents selected from the group consisting of hydroxy, alkoxy, and halogen; and

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E when present is a cross linking monomer for introducing branching and controlling molecular weight, the cross linking monomer comprising polyfunctional units carrying multiple reactive functionalization groups selected from the group consisting of vinyl, allylic and functional mixtures thereof, the groups A, B, C, D and E being covalently bonded one to another in a random, a block or a cross-linked copolymer format.

2. The copolymer according to claim 1 wherein monomer C is selected from the group consisting of ethylacrylate, methylacrylate, ethylmethacrylate, methylmethacrylate, butylacrylate, butyl methacrylate and mixtures thereof.

3. The copolymer according to claim 1 wherein the associative monomer D has the formula:



wherein n ranges from 18 to 25 and m ranges from 23 to 25.

4. The copolymer according to claim 1 wherein the associative monomer D is selected from the group consisting of cetyl polyethoxylated methacrylate, cetearyl polyethoxylated methacrylate, stearyl polyethoxylated (meth)acrylate, arachidyl polyethoxylated (meth)acrylate, behenyl polyethoxylated methacrylate, lauryl polyethoxylated methacrylate, hydrogenated castor oil polyethoxylated methacrylate, and canola polyethoxylated (meth)acrylate.

5. The copolymer according to claim 1 wherein all acid units are in salt form.

6. The copolymer according to claim 1 wherein

a ranges from about 0.3 to about 5% by weight of the copolymer;

b ranges from about 25 to about 70% by weight of the copolymer;

c ranges from about 45 to about 75% by weight of the copolymer;

d ranges from about 3 to about 20% by weight of the copolymer; and

e ranges from about 0.01 to about 5% by weight of the copolymer.

7. The copolymer according to claim 1 wherein the polyacidic vinyl monomer is selected from the group consisting of maleic anhydride, maleic acid and salts thereof.

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